

Date: Thursday, 12/13/2007 2:42:20 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARSHOE	
Job Number	: 36338		Part Number	: D35645	
Estimate Number	: 12786		Drawing Number	: D3564 REV0	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	12/13/2007	S.O. No. : N/A	Drawing Revision	: D	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	12/20/2007	Qty: 30
Previous Run	: 36111		Um:	20	Each
Written By	:				
Checked & Approved By	:				
Comment	: Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet 36.6267
Comment: Qty.: 1.1099 sf(s)/Unit Total : 22.1970 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: 106653 B 08-1-2		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3564 Dwg Rev: D B 08-1-2 Prog Rev: D (33)		
2-Deburr if necessary B 08-1-2		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE B 08-1-2
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK B 08-1-2 (X33)		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT and DT 8179 8155 8108 08/01/09 (33)		
Form Joggle as per Dwg D3564 on brake using Jig DT 9157 8108 08/01/09 (33)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/01/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: WEARSHOE

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

✓ 08/01/09 x33

7.0 POWDER COATING POWDER COATING



M106442

(33X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-1 08/01/10

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



✓ 08

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-01-10 x33

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: FP-18

✓ 08

08-01-10 x33

10.0 QC21 FINAL INSPECTION/W/O RELEASE



(33)

Comment: FINAL INSPECTION/W/O RELEASE

10 08/01/11

Job Completion



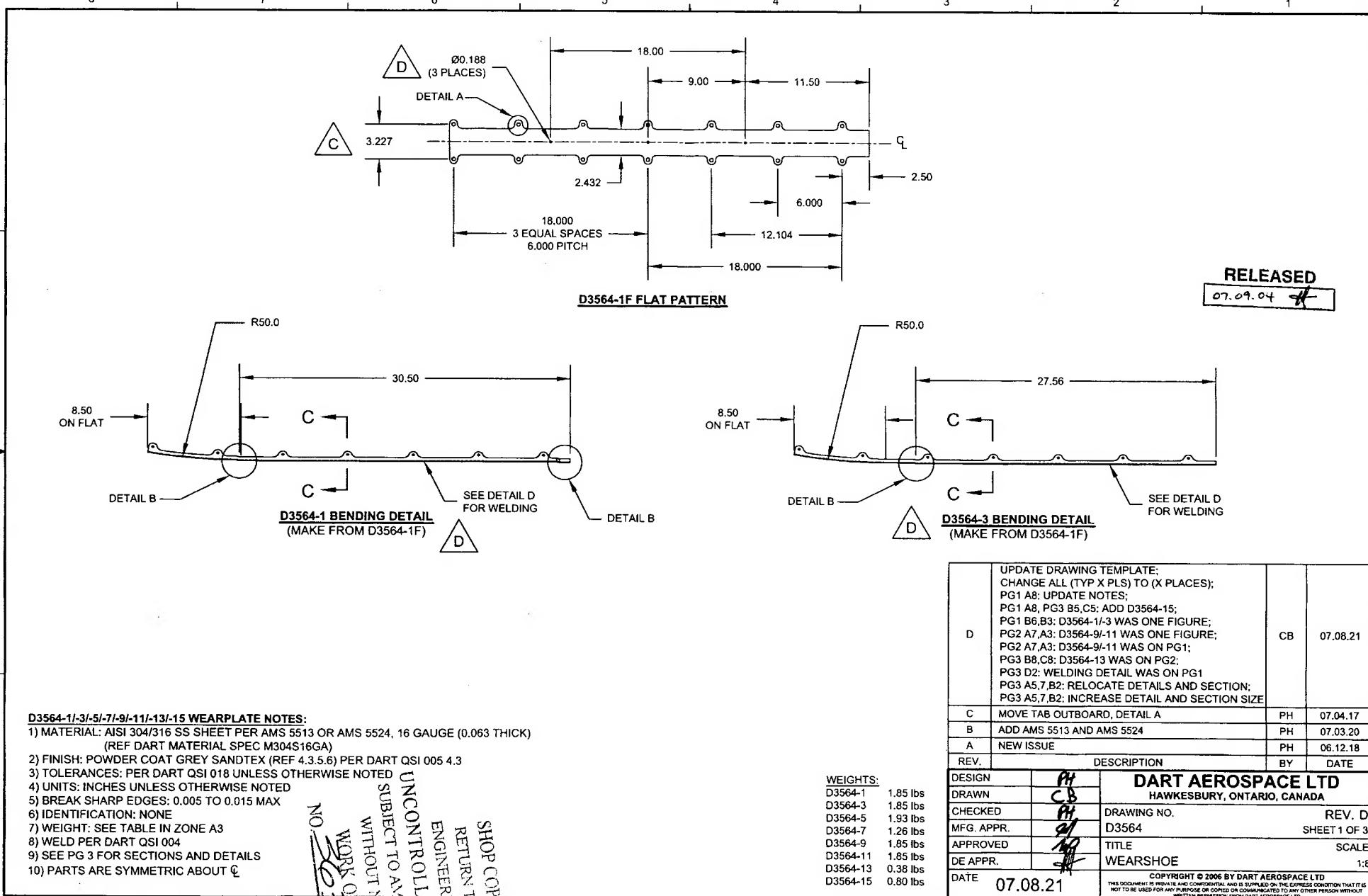
✓ 08/01/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

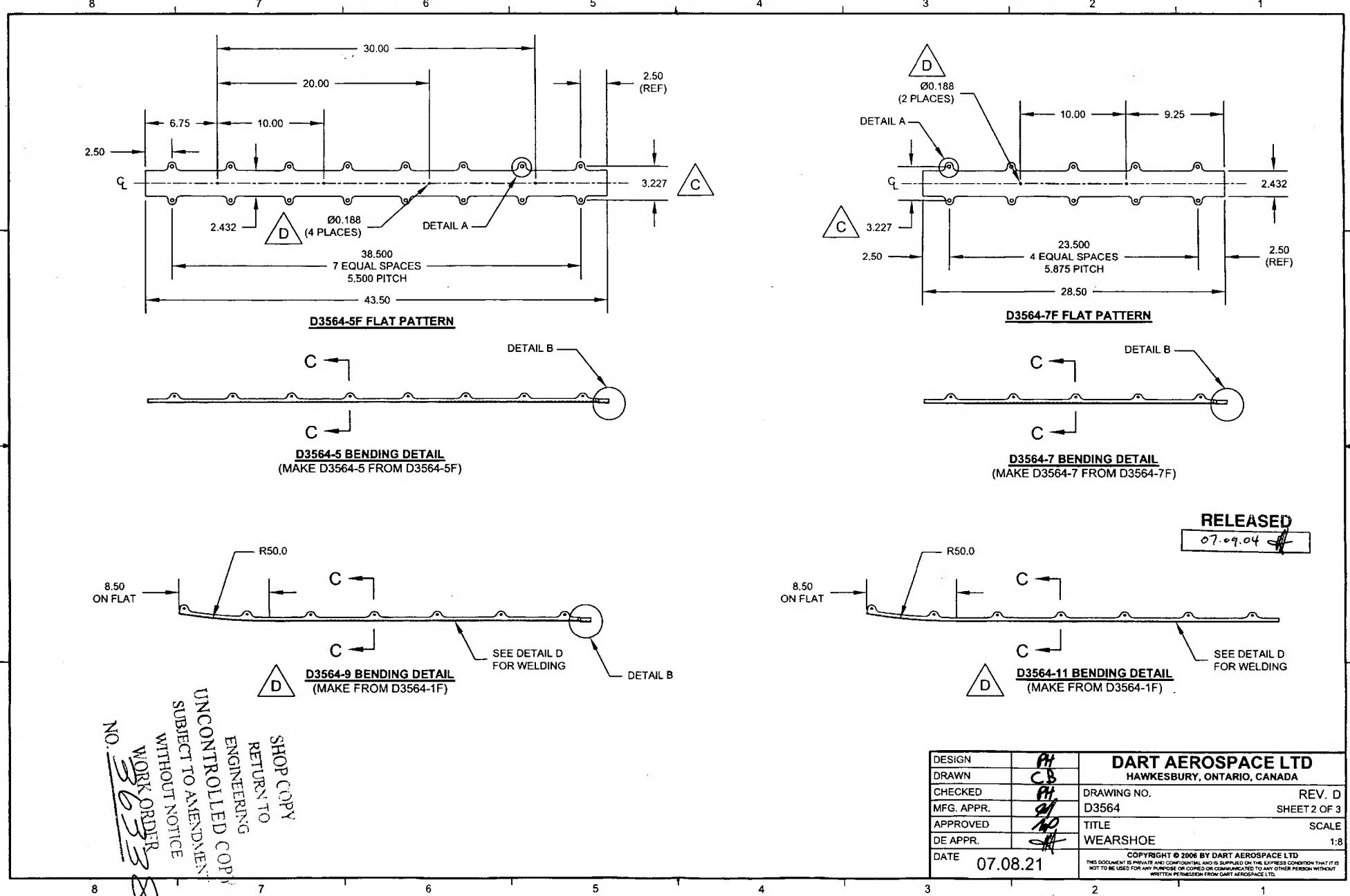
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

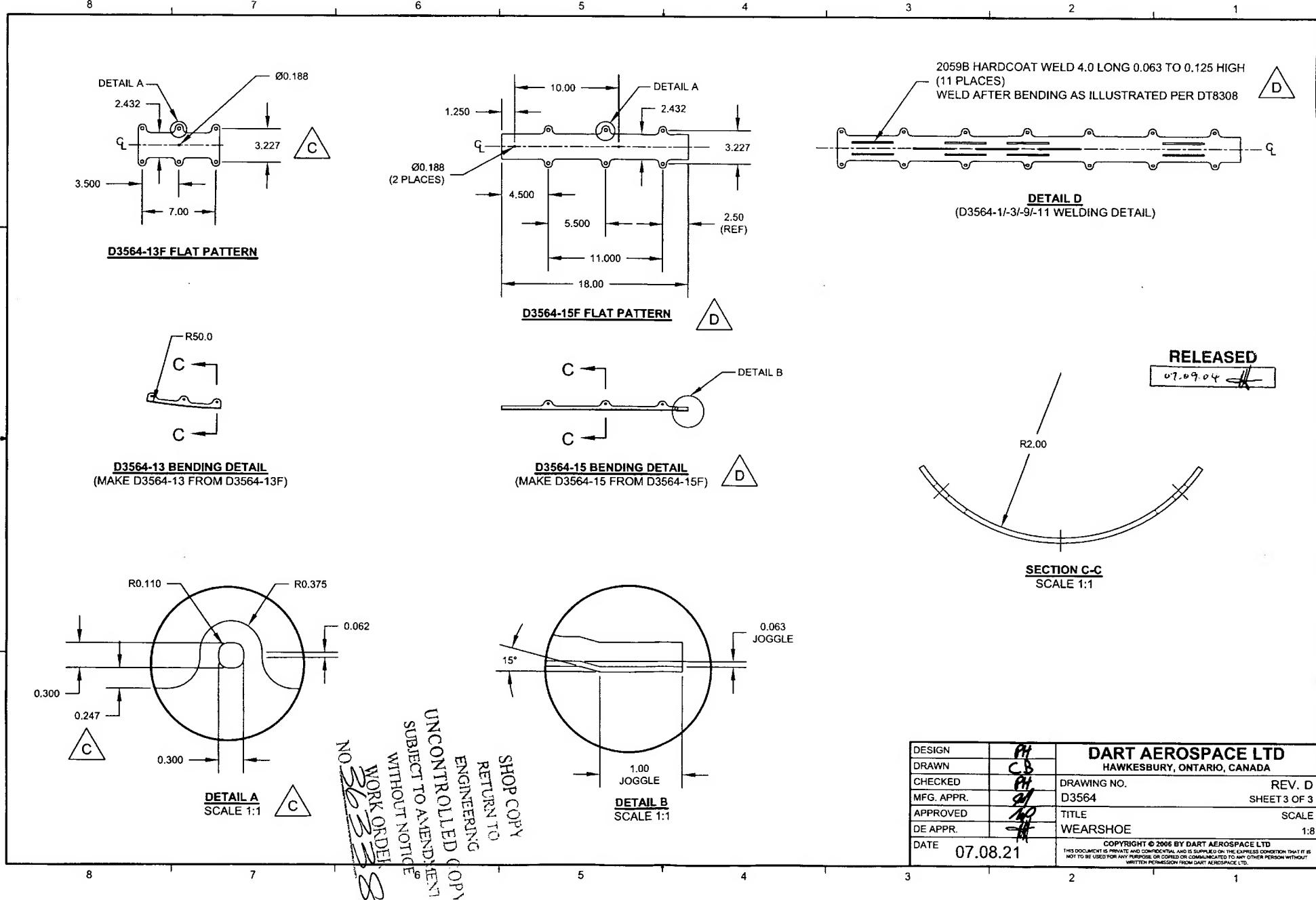
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB	DRAWING NO.	REV. D
CHECKED	PH	D3564	SHEET 1 OF 3
MFG. APPR.	SI	APPROVED	SCALE
DE APPR.	SI	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS RESTRICTED BY LAW FROM DIVULGATION. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	





CART AEROSPACE LTD	Work Order:	36338
Description: WEAR SHOE	Part Number:	D3564-5
Inspection Dwg: D3564-5 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>LB</u>	Audited by: <u>J</u>	Prototype Approval: <u>1/</u>
Date: <u>08-1-3</u>	Date: <u>08/01/03</u>	Date: <u>8</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	